

46

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	19855
<b>Description:</b> Spacepod Hardware Kit		<b>Part Number:</b>	K10018
-1			
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C		<b>Qty:</b>	4 Kits
RF 03.04.30			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: K10018 Kit to be made in multiples of 7.</b> <b>(1) K10018 requires (2) D2174-041.</b> <b>(1) D2174-041 consists of (1) D2174-1 Web &amp; (2) D2175 Angle</b>	KJ	03.10.27	4
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2174-1</b> Batch: _____			
3	MV	<b>Cut (2) blanks per (1) K10018 Kit</b> Cut blanks: (12.200" x 2.960") <b>grain along 2.960</b> Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2175</b> Batch: _____			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 <b>Identify as D2174-1</b>			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 <b>Identify as D2175</b>			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 <b>Pick:</b> Qty Part Number Description Batch 23 MS20470AD4-6 Rivet _____ <b>Identify as D2174-041</b>			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	19855
<b>Description:</b> Spacepod Hardware Kit	<b>Part Number:</b>	K10018
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	<b>Qty:</b>	4 Kits
RF 03.04.30		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																																
21	KP	<p>Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 &amp; 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2174-041</td><td>Web Assembly</td><td>B13732</td></tr><tr><td>1</td><td>D2985</td><td>Decal</td><td>B14100</td></tr><tr><td>8</td><td>A3235-020-935</td><td>Washer</td><td></td></tr><tr><td>16</td><td>AKS7-1032-130</td><td>Insert</td><td>M6087</td></tr><tr><td>8</td><td>AN3-3A</td><td>Bolt</td><td>M3155</td></tr><tr><td>8</td><td>AN3H4A</td><td>Bolt (or AN3H4)</td><td>M12493</td></tr><tr><td>36</td><td>AN525-10R7</td><td>Screw</td><td>M13536</td></tr><tr><td>8</td><td>AN960JD10</td><td>Washer</td><td>M13441</td></tr><tr><td>16</td><td>AN960JD10L</td><td>Washer</td><td>M12749</td></tr><tr><td>16</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M13536</td></tr><tr><td>8</td><td>MS24694S67</td><td>Screw</td><td>M9404 M9750</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2174-041	Web Assembly	B13732	1	D2985	Decal	B14100	8	A3235-020-935	Washer		16	AKS7-1032-130	Insert	M6087	8	AN3-3A	Bolt	M3155	8	AN3H4A	Bolt (or AN3H4)	M12493	36	AN525-10R7	Screw	M13536	8	AN960JD10	Washer	M13441	16	AN960JD10L	Washer	M12749	16	MS21042L3	Nut (or -3)	M13536	8	MS24694S67	Screw	M9404 M9750	SD	03/10/13	4
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22	QC4	Inspect Kit 100% for Completeness on the W/O	Li	03-12-19	4																																																
23	ST	Identify and Stock	SB	03/12/19	4																																																
24	AC	Cost / part 61.45	Sgt	03-12-22	4																																																
25	DC	Close W/O 60.39 Inspect Level 21	AJ	03.12.23	4																																																

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	

RELEASED  
03.04.30

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#:\_\_\_\_\_ Fault Category:\_\_\_\_\_ DQA:\_\_\_\_\_ Date:\_\_\_\_\_

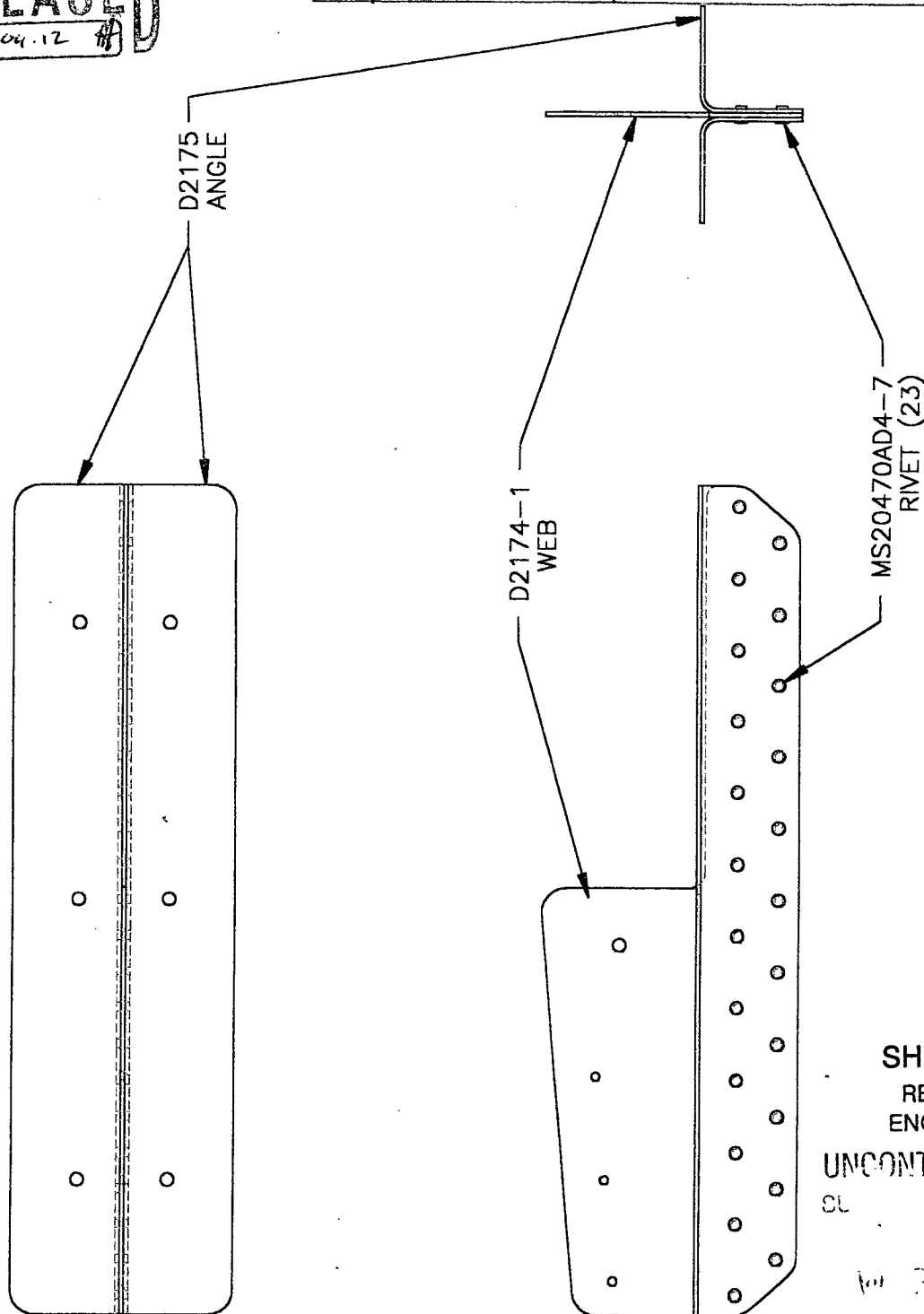
NOTE: Date & initial all entries  
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. #
BW	[Signature]	D2174-041	00.07.06
DATE	TITLE		SHEET 1 OF 1
95:10:25	WEB ASSEMBLY		SCALE
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC. [Signature] CP	

RELEASED  
00.04.12 [Signature]



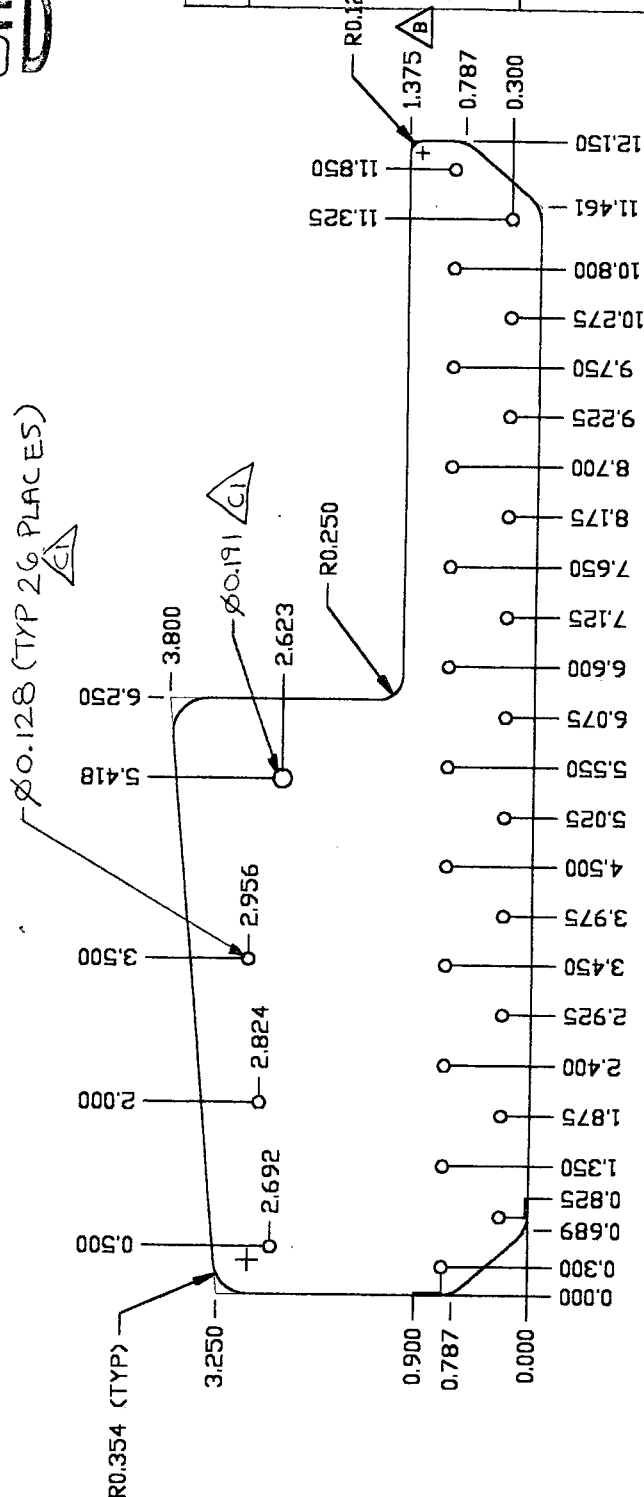
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK  
FINISH: ANODIZE CLEAR POWDER COAT WHITE PER DART Q.S.I 005 43.5.1

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
CL AMENDMENT  
NOTICE  
RK ORDER  
NO. 19855



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED Bo	APPROVED [Signature]	DRAWING NO. D2174-1	REV. # SHEET 1 OF 1
DATE 95:10:25	TITLE WEB		
B	96.01.18	RE-DRAWN CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. # CP	

RELEASED  
00.09.12 #



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 19855

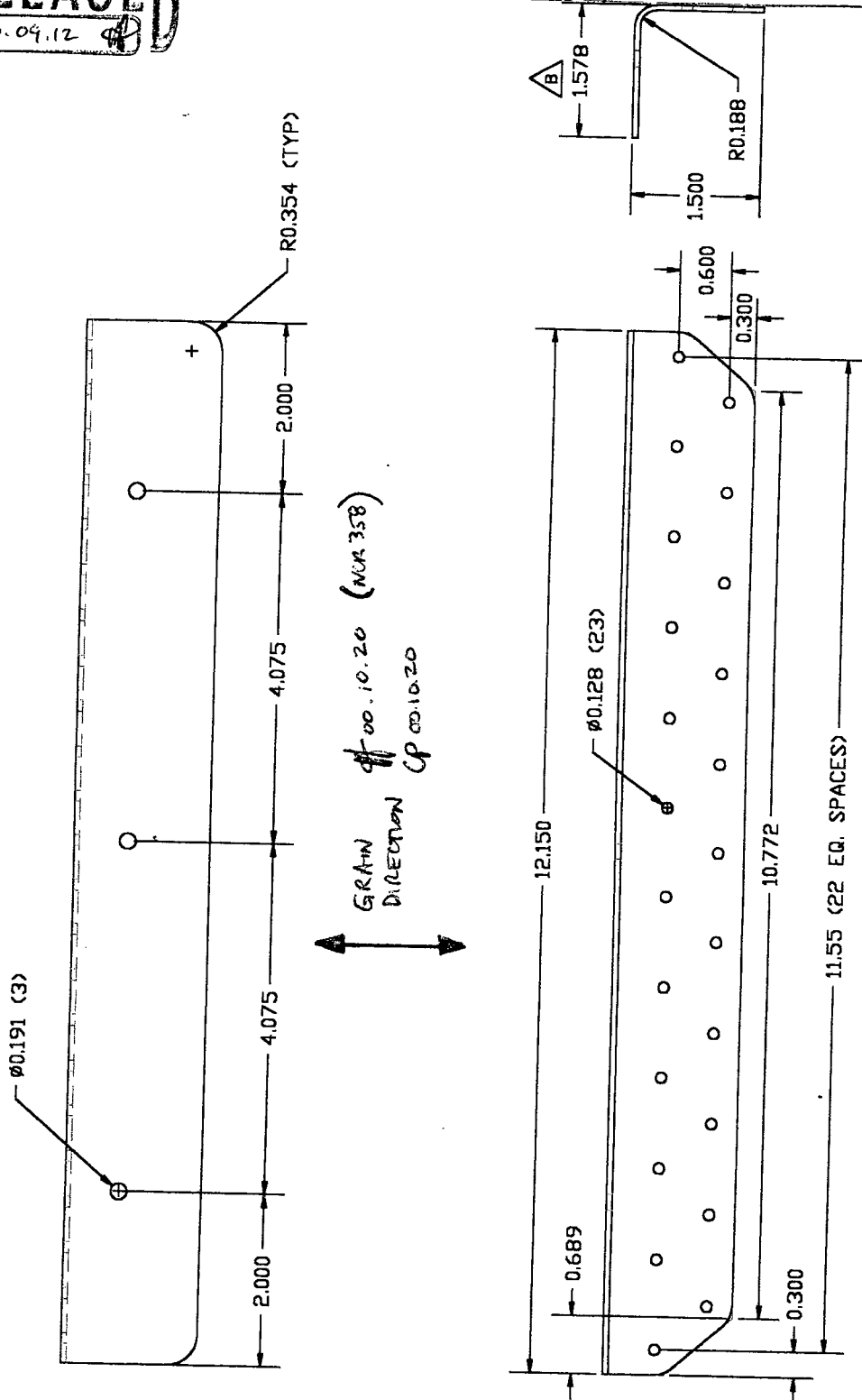
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4-1  
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK

CI 01.02.22 ADD HOLE DIMENSIONS # CP



RELEASED  
00.09.12

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. #
CHECKED BW	APPROVED [Signature]	D2175	SHEET 1 OF 1
DATE	TITLE		SCALE
95:10:25	ANGLE		
B	96.01.18	CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. [Signature] CP	



MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK  
FINISH: ANODIZE CLEAR  
CHEMICAL CONVERSION COAT PER DART  
Q ST 005 4.1

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UNCONTROLLED COPY  
REVISION  
CUT NOTICE  
WORK ORDER  
NO. 19855

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 27, 2003  
07:53 am

Work Order No	: 0019855	Department Code:	
Project Name	: K10018	Burden Flags	: NNNNNNNN
Project For	: WK346	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: K10018	Invoice Number	:
Description	: Spacepod Hardware Kit	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-27-03		
Est Finish Date	: 11-13-03	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00